

Date: Wednesday, 25/06/2008 11:59:58 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HI-STEP LEG ASSEMBLY
Job Number :	40087		
Estimate Number :	10355		
P.O. Number :		Part Number :	D2582
This Issue :	25/06/2008	Drawing Number :	D2582 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	B
Previous Run :	37925	Material :	
Written By :		Due Date :	07/07/2008
Checked & Approved By :	<u>JULIE LECOCQ</u>	Qty:	14
Comment :	Est Rev:F Removed Manufacturing 05-11-07 JLM Est Rev:G Added part # to Sub 06-08-10 JLM Est Rev H New pick list 08.01.11 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	40087A	STEP LEG
	Comment: Sub-Component STEP LEG 2 x D2278 Batch <u>B40087A</u>	
2.0	40087B	STEP SPACER
	Comment: Sub-Component STEP SPACER 1 x D2322 Batch <u>B40087B</u> (9x) <u>B37925B</u> (5x)	
3.0	40087C	STEP SPACER
	Comment: Sub-Component STEP SPACER 1 x D2279 Batch <u>B3407D</u>	
4.0	40087D	STEP SPACER
	Comment: Sub-Component STEP SPACER 1 x D3720-1 Batch <u>B37925D</u> (5x) <u>B40087D</u> (9x)	
5.0	40087E	STEP SPACER
	Comment: Sub-Component STEP SPACER 1 x D3720-2 Batch <u>B37925E</u> (8x) <u>B40087E</u> (6x)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 11:59:58 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 40087

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 MS20470AD4-4

Rivet

M107823

08/07/16

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS20470AD4-5

Rivet

M106918

08/07/16

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

08/07/16 (14)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/16 (14)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W14

08.07.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22

Job Completion



mf 08-07-22

Dart Aerospace Ltd

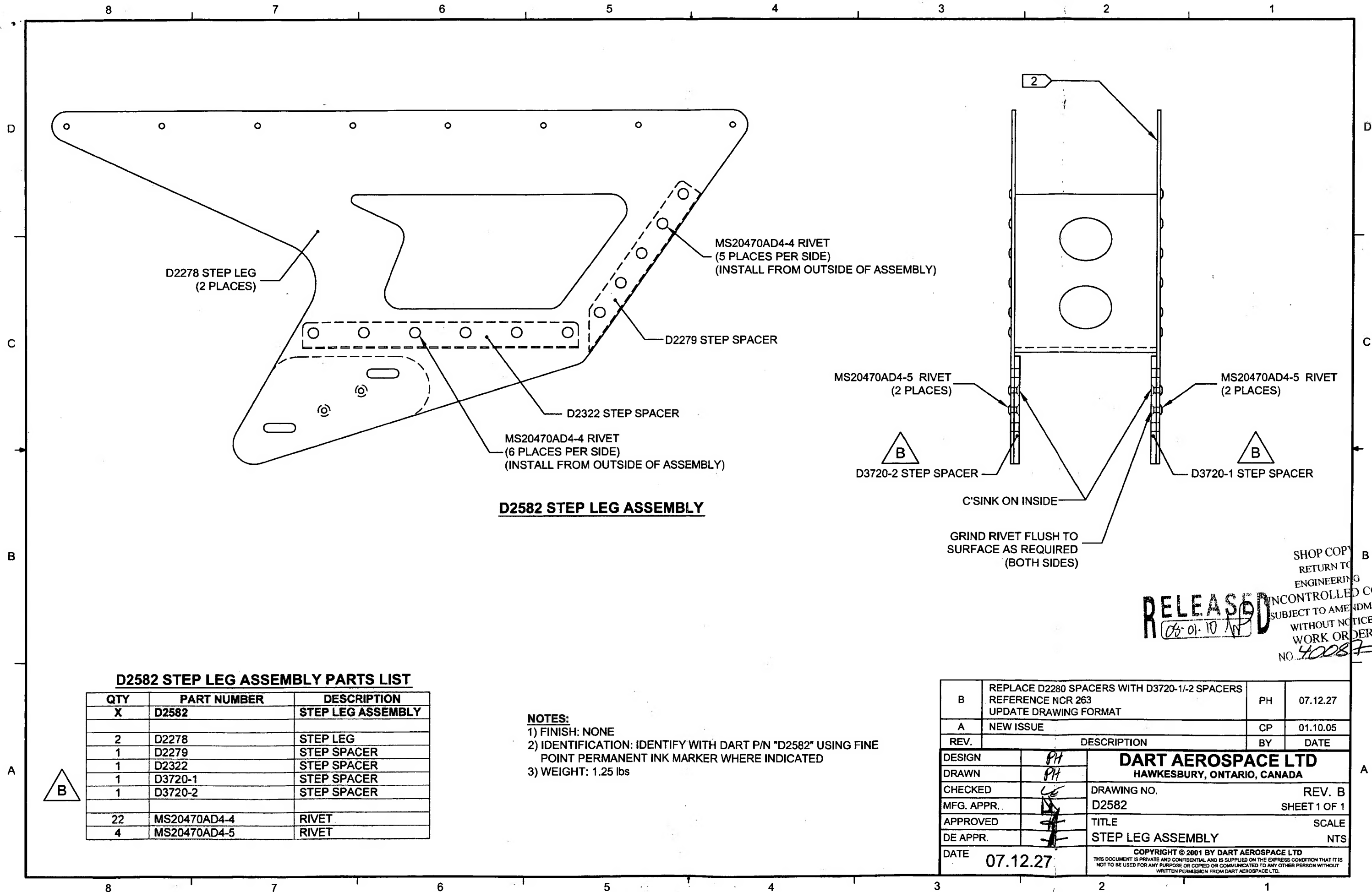
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2279 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
(2 PLACES)

MS20470AD4-5 RIVET
(2 PLACES)

D3720-2 STEP SPACER

D3720-1 STEP SPACER

C'SINK ON INSIDE

GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

- NOTES:**
1) FINISH: NONE
2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
3) WEIGHT: 1.25 lbs

REV. B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
REV. A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. REV. B D2582 SHEET 1 OF 1	
CHECKED	LE	TITLE SCALE STEP LEG ASSEMBLY NTS	
MFG. APPR.	LE	DATE 07.12.27	
APPROVED	LE	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	LE		

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40087

RELEASED
06-01-10

